



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4956-33
Job Sheet 173015



Part No: D4956-33

Job Qty: 8 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV A SHEETS 5,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	3/3/18	3/3/18	0.00	0.00	Start Up Waterjet		SC 18/03/18
100	Waterjet	8 pcs	3/3/18	3/3/18	0.00	1.42	Waterjet1		SC 18/03/18
110	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC2 Waterjet-1		SC 18/03/18
120	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC8-5		38
130	Brake NC	8 pcs	3/3/18	3/3/18	0.00	0.24	Brake NC 1		38
140	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC5		38
150	HandFinish	8 pcs	3/5/18	3/5/18	0.00	0.28	HandFinish4		AS 9-15-2018
160	QC	8 pcs	3/5/18	3/5/18	0.00	0.00	QC3		11
170	Packaging	8 pcs	3/5/18	3/5/18	0.00	0.00	Packaging3-2		FP002 8
180	QC21-SA	8 Ea	3/5/18	3/5/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Form as per dwg
 140 - QC5- Inspect part completeness to step on W/O
 150 - 1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING
 B#: 138819
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____ LOCATION : FP002
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	5.6000 sf (.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	6	169	0

Part Specifications

Specifications could not be found.



Container No: S050576



Part: D4956-33

Job No: 173015

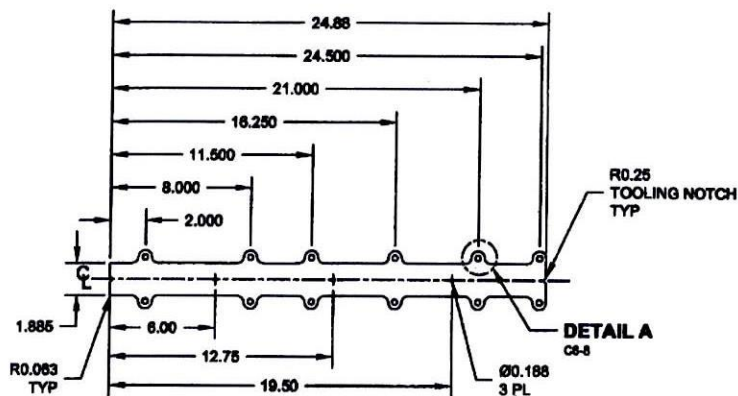
Serial No/Batch: S050576

Revision:

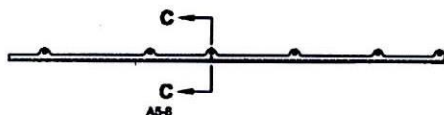
Inspector:

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

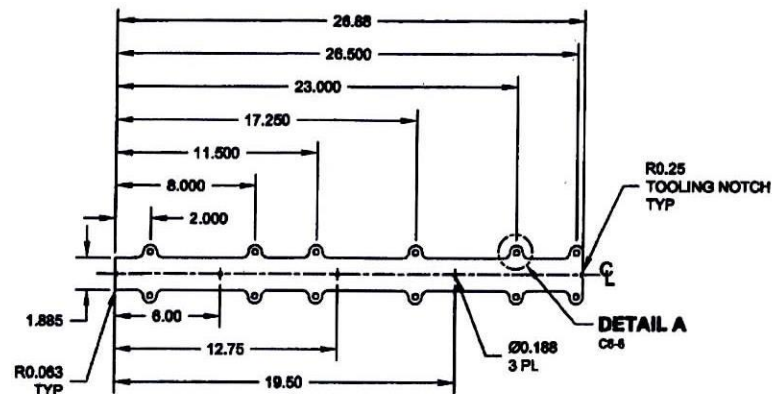
Date: 03/13/18



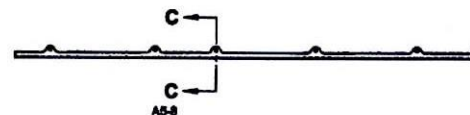
D4956-31F FLAT PATTERN



D4956-31 WEARSHOE
(MAKE FROM D4956-31F)



D4956-33F FLAT PATTERN



D4956-33 WEARSHOE
(MAKE FROM D4956-33F)

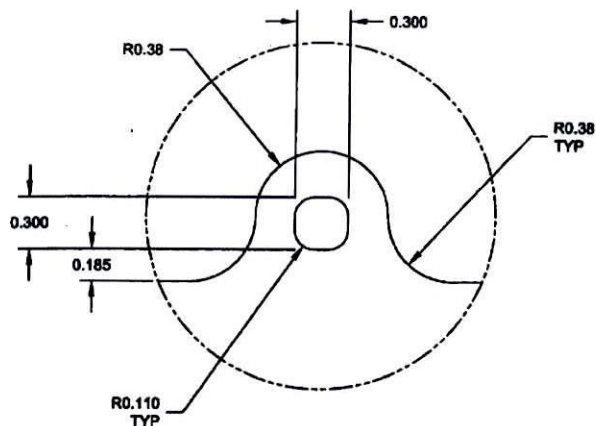
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-31 = 0.57 lbs; D4956-33 = 0.61 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

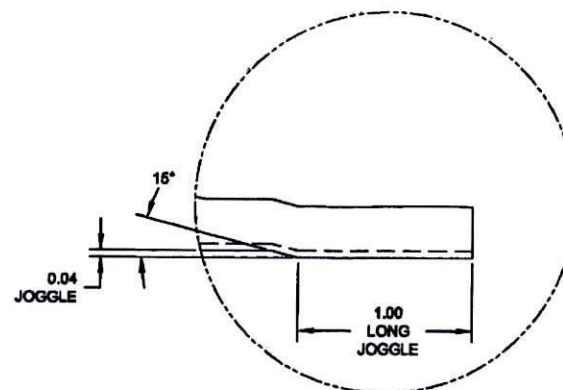
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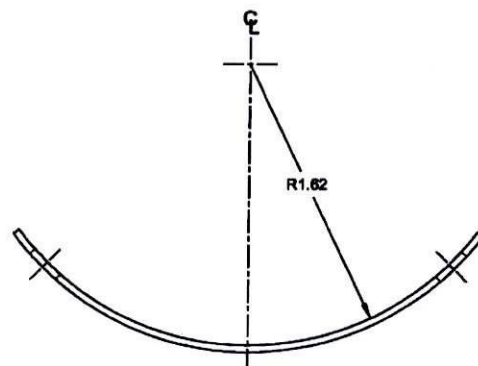
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4956	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C2-4
C8-6 C2-6
C8-8 C2-8
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B6-4
B7-6 B3-6
B7-6 B3-6
B7-7 B3-7

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CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DS	D4956	SHEET 8 OF 8
APPROVED	12	TITLE	SCALE
DE APPR.	12	WEARSHOE	NT
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